

Date: Tuesday, 06/05/2008 3:49:45 PM
 User: Julie Lecocq

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BEARPAW KIT (13"X24")
Job Number : 39081	
Estimate Number : 11540	
P.O. Number :	Part Number : D206559023
This Issue : 06/05/2008 S.O. No. :	Drawing Number : D2672 REV B1
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : MACHINED PARTS	Drawing Revision : B1
Previous Run : 34856	Material :
Written By :	Due Date : 22/05/2008 Qty: 4 Um: Each
Checked & Approved By : <i>JLD 08.5.08</i>	
Comment : Est Rev: E 04.02.17 Tolerance added to Step 3 KJ/JLM	
Est Rev: F 07-01-02 Was K10006 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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**Comment:** DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-559-023 CHG006

S 08/06/10 08.5.08 JLD

2.0	MUHMWB10	UHMW 1" Black
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Comment: Qty.: 4.8300 sf(s)/Unit Total : 19.3200 sf(s)
 blank: 13.250" x 24.25" x 1.00" thick (+0.030/-0.000) per DSK086-2
 Material: Black UHMW 1"
 (MUHMWB10)
 Batch: *M108013*

M.A 08/06/04

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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**Comment:** HAAS CNC VERTICAL MACHINING #1

Note:(2) bearpaws for (1) Kit

1-Inspect material for defects or damage prior to machining

2-Machine as per Folio and Dwg D2672 Identify as D2672

3-Deburr

M.A/gmk 08/06/07

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	----------------------------------------

**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

M.A/gmk 09/06/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 06/05/2008 3:49:45 PM
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Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

J.L 08/06/10

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

7.0

D2182B

Rubber Cushion



Comment: Qty.: 2.5000 f(s)/Unit Total: 10.0000 f(s)

Pick: Packing Kit

Qty Part Number Description Batch
6 D2182B050 Rubber Cushion

B35769

J.S 08/06/10

8.0

D2274

Radius Block



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
12 D2274 Radius Block
2 D2672(ref only) Bearpaw

37630
39081

J.S 08/06/10 (x4)

9.0

D2438

Clamp



Comment: Qty.: 6.0000 Each(s)/Unit Total: 24.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
6 D2438 Clamp

37630
37552

J.S 08/06/10 (x4)

10.0

D2529

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total: 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch
12 D2529 Washer

37210

J.S 08/06/10 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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Job Number: 39081

Part Number: D206559023

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2732

Rubber Extrusion



Comment: Qty.: 0.4160 Each(s)/Unit Total : 1.6640 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

6 D2732-050 Rubber Cushion 37632

AS 08/06/10 (x4)

12.0

AN415A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-15A Bolt M107737

AS 08/06/10 (x4)

13.0

AN417A

Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 AN4-17A Bolt M105653

AS 08/06/10 (x4)

14.0

AN960JD416

Washer



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

24 AN960JD416 Washer M107939

AS 08/06/10 (x4)

15.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick: Packing Kit

Qty Part Number Description Batch

12 MS21042L4 Nut (or -4) M107478

AS 08/06/10 (x4)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

S 08/06/10 (40)

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPPD206-559-023

Location:

Per A

AS 08/06/10 (40)

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/06/10 (40)

Job Completion



W 08-06-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 39081
Description: Bearpaw		Part Number: D2672
Inspection Dwg: D2672 Rev: B1		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	23.750	+/-0.030	23.750	✓		tape	
B	12.750	+/-0.030	12.750	✓		tape	
C	4.250	+/-0.010	4.250	✓			
D	2.000	+/-0.030	1.999	✓			
E	9.000	+/-0.010	9.000	✓			
F	0.375	+/-0.030	0.375	✓			
G	9.000	+/-0.010	9.000	✓			
H	Ø0.260	+0.005/-0.000	Ø0.260	✓			
I	Ø0.93	+/-0.030	Ø0.931	✓			
J	0.300	+0.030/-0.000	0.305	✓			
K	0.625	+/-0.030	0.623	✓			
L	0.063 x 45°	+0.030/-0.010	0.063 x 45°	✓			
M	0.250	+/-0.010	0.249	✓			
N	5.500	+/-0.030	5.500	✓			
O	R0.250	+/-0.030	R0.250	✓			
P	0.200	+/-0.030	0.199	✓			
Q	0.25 x 45°	+/-0.030	0.252 x 45°	✓			
R	0.950	+0.030/-0.010	0.948	✓			
S	0.375	+/-0.010	0.370	✓			

Measured by: H.A. [Signature]	Audited by: DIP	Prototype Approval: N/A
Date: 08/06/07	Date: 08/06/07	Date:

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue	KJ/RF [Signature]	[Signature]

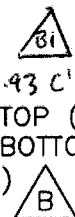
DART



DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B
LE	LE	DRAWING NO.	D2672	SHEET 1 OF 2
CHECKED M	APPROVED S	TITLE	BEARPAW	SCALE 1:5
DATE 98.05.19				
A	97.04.08	NEW ISSUE		
B	98.05.19	CHANGE C'BORE, R1.58 WAS R1.50		
B1	98.10.22	φ0.93 WAS φ0.75		

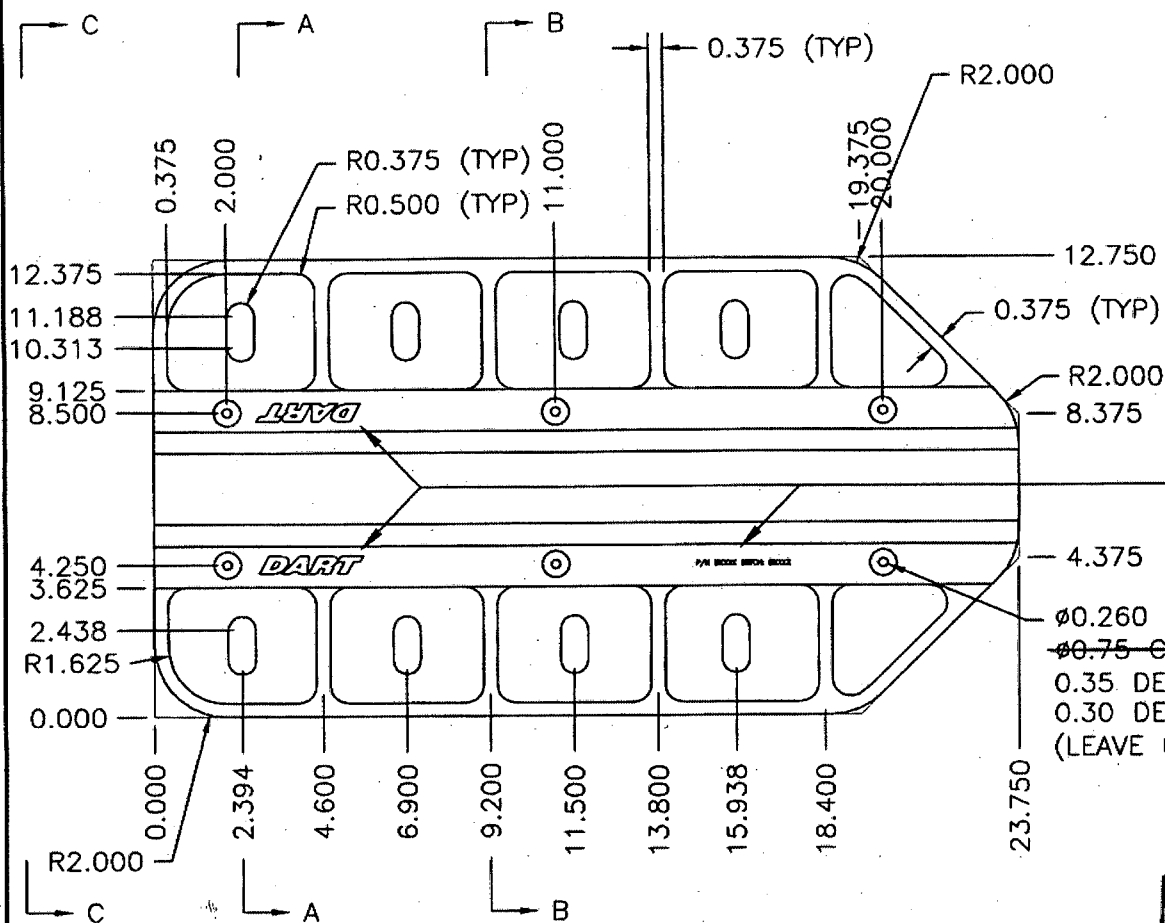
ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ ~~φ0.93 C'BORE~~
 0.35 DEEP FROM TOP (MIN.)
 0.30 DEEP FROM BOTTOM (LEAVE 0.300 MIN.)

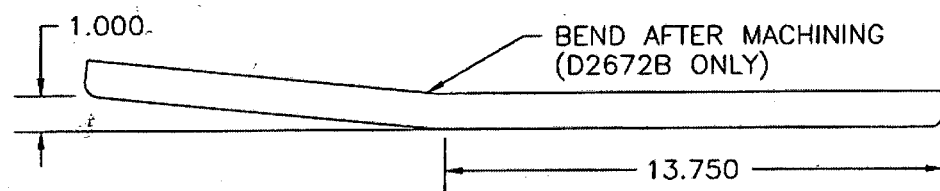


EFFECTIVE	DEOS
9/43	

RELEASED
 98.06.17 KS



FLAT PATTERN



D2672F: FLAT BEARPAW
 D2672B: BENT BEARPAW

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
 1.00 THICK (MACHINE TO 0.950)

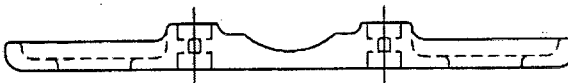
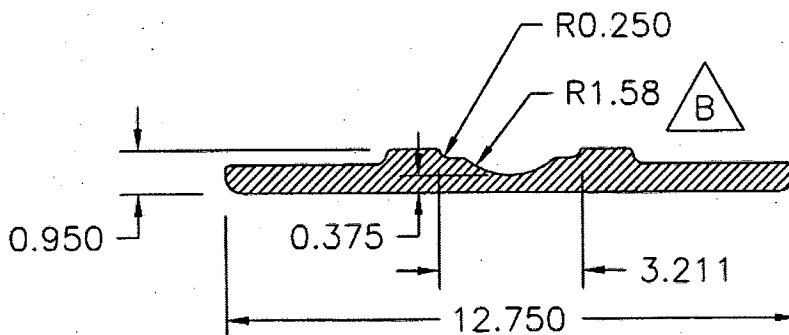
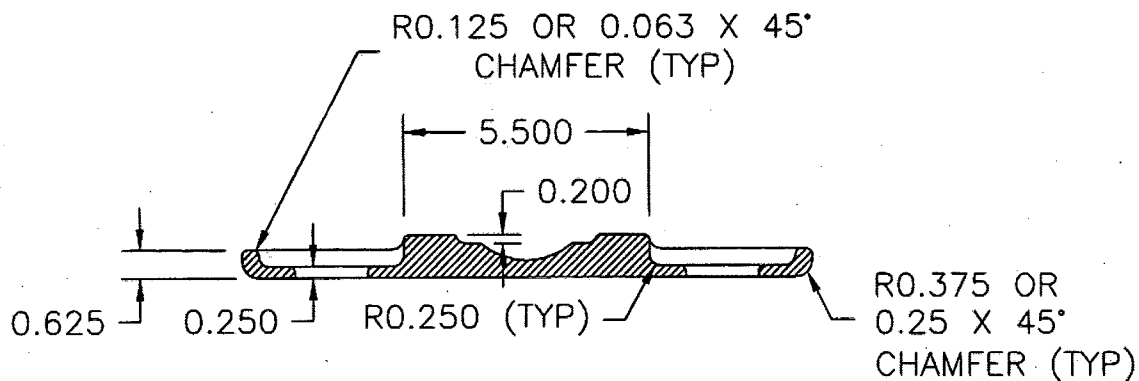
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 RETURN TO
 SHOE COPY



DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2672	REV. B SHEET 2 OF 2
DATE 98.05.19	TITLE BEARPAW		SCALE 1:4

RELEASED
99.06.17 KE



SECTION C-C

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